

ASAP

Date: Monday, 06/11/2006 2:44:22 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 29366	
Estimate Number : 10554	
P.O. Number : N/A	Part Number : D34431
This Issue : 06/11/2006 S.O. No. : N/A	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28184	Material : N/A
Written By : <u> </u>	Due Date : 13/11/2006 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2500X1250	17-4 SS BAR
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Comment: Qty.: 0.2100 f(s)/Unit Total: 1.6800 f(s)
Material: 17-4 SS Bar 2.500" X 1.250"
(M17-4-B2.500x01.250)
Batch: M101422

J.F. 06/11/06

(8)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 2.400 " long

J.F. 06/11/06

(8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA587 Rev: A & Dwg D3443 Rev: B

J.F./J.L 06/11/06

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06/11/08

8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.M 06/11/08

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/11/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/11/2006 2:44:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 29366

Part Number: D34431

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Tumble & deburr per dwg D3443

J.L 06/11/08 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 06/11/08 8

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST435

B 06/11/08 8

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/10 8

Job Completion



U 06/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

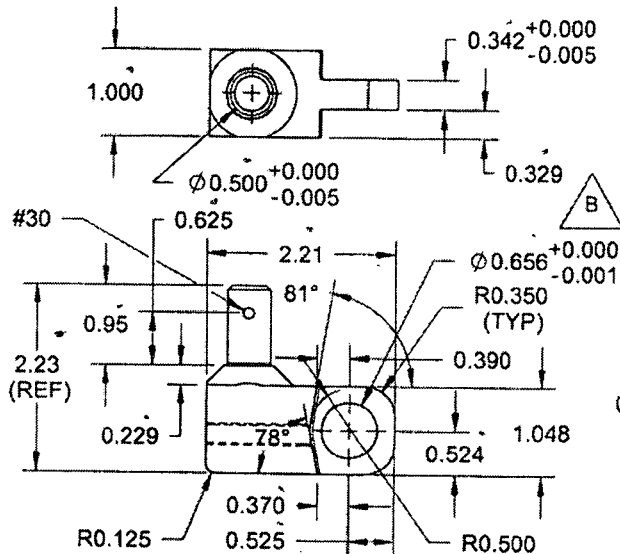
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

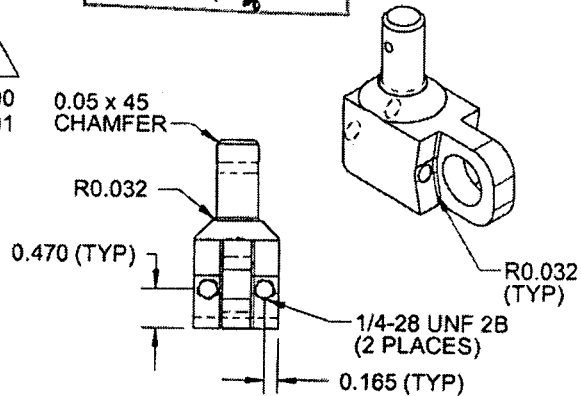
342
337
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2		



RELEASED

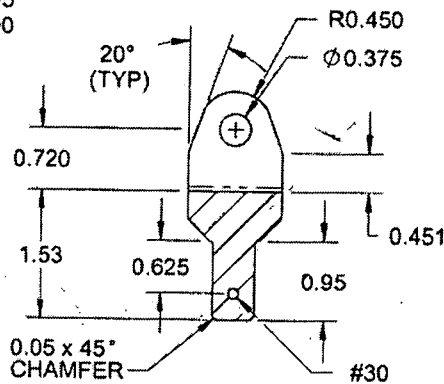
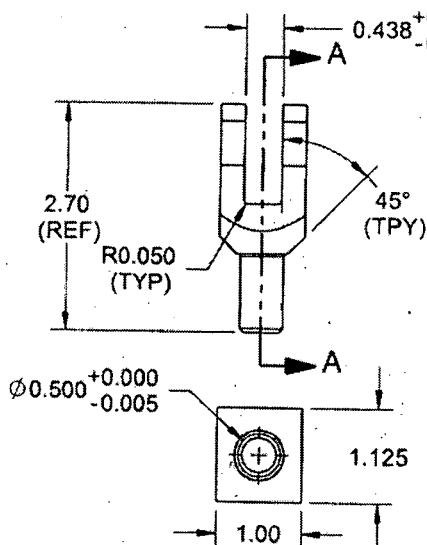
05.12.04 #



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY

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D3065-5DART AEROSPACE LTD		Work Order: 29366
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.004	✓			
0.342	+0.000/-0.005	.342	✓			
0.329	+/-0.010	.329	✓			
Ø0.500	+0.000/-0.005	.4998	✓			
2.21	+/-0.030	2.212	✓			
Ø0.656	+0.000/-0.001	.655	✓			
0.625	+/-0.010	.627	✓			
0.95	+/-0.030	.951	✓			
2.230	+/-0.010	2.228	✓			
0.229	+/-0.010	.232	✓			
0.370	+/-0.010	.372	✓			
0.525	+/-0.010	.525	✓			
0.524	+/-0.010	.524	✓			
0.390	+/-0.010	.388	✓			
1.048	+/-0.010	1.048	✓			
0.05 x 45°	+/-0.5°	.05x45°	✓			
R0.032	+/-0.010	.032	✓			
0.470	+/-0.010	.470	✓			
0.165	+/-0.010	.166	✓			
1/4-28UNF	N/A	1/4-28unf	✓			

Measured by: J.L	Audited by: E.P	Prototype Approval:	N/A
Date: 06/11/07	Date: 06/11/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	